

Work Order ID **55863**



Page 1

February 3, 2010 1:13:43 PM

Item ID: D3999-11

Accept



Setup

Start



Stop



Revision ID:

Item Name: Earth Tab

Start Date: 2/03/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/10/10 Req'd Qty: 2.00

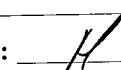


Customer:

Reference:

Approvals:

Process Plan:



Date: 10/20/03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3999

A-PRELIM

Rev. A E

0.00

100



Waterjet

FLOW CNC Waterjet

6661.063

Memo

0.00

1-Cut as per Dwg  
Dwg Rev: QRF  
Prog Rev: PLM

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

PRELIMINARY ISSUE

10/02/17

10/02/17

(6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Work Order ID 55863



Page 2

February 3, 2010 1:13:43 PM

Item ID: D3999-11

Accept



Setup Start



Stop



Revision ID:

Item Name: Earth Tab

Start Date: 2/03/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/10/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
Description

120



QC

Quality Control

130



Brake NC

Brake NC

150



HandFinish

Hand Finishing

Bend as per dwg

Memo

Set Up/  
Run Hours

0.00

S10217

Draw  
Number

0.00

Draw  
Rev.

0.00

Plan  
Code

0.00

Accept  
Qty

0.00

Reject  
Qty

0.00

Reject  
Number

0.00

Insp.  
Stamp

(6)

0.00

S102122

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

S102123

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Work Order ID 55863



Page 3

February 3, 2010 1:13:43 PM

Item ID: D3999-11

Accept



Setup

Start



Stop



Revision ID:

Item Name: Earth Tab

Start Date: 2/03/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/10/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Quality Control

QC5- Inspect part completeness to step on W/O

QC - Inspect part completeness to step on W/O

S10/01/10 To Releas Day only  
Memo

0.00

QC APPROVAL

S

10/23  
to K.W.S

not inspated

No changes From PA1 to Rev A Day.

170



Packaging

Packaging

Identify as per dwg & Stock Location: Potem  
Shelf

0.00

S10/01/14

0.00

(6)

S109

10/7/27 SK 52

180



Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/28 88

MF  
10-4-21

POSITIVE RECALL

EFFECTIVE 10-07-02 AUTH [Signature]

RELEASED

DATE 10-7-26  
QTY 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

February 3, 2010 1:13:48 PM

Page 1

**Work Order ID:** 55863**Parent Item:** D3999-11**Parent Item Name:** Earth Tab**Start Date:** 2/03/10**Required Date:** 2/10/10**Comments:** IPP rev A 09.12.18 new issue Prelim EC verified by:DD**Start Qty:** 2.00**Required Qty:** 2.00

<b>Component Item ID/ Item Name</b>	<b>Replacement Item ID</b>	<b>Mfg/ Purch</b>	<b>Bin Item</b>	<b>Primary Location</b>	<b>Last Location</b>	<b>Route Seq ID</b>	<b>Unit of Measure</b>	<b>Qty on Hand</b>	<b>Remaining Qty To Pick</b>	<b>Qty Issued</b>	<b>Date Issued</b>	<b>Status</b>
M6061T6S.063		Purchased	No			100	sf	302.8841	0.0211	1	HB 10-2-17	

6061-T6 .063 Sheet

<b>Warehouse</b>	<b>Loc Qty</b>	<b>Loc Code</b>
<b>Location</b>		
Main Warehouse		
MAT	302.8841211	
110551	25.2841211	110551
113608	277.6	(6)

OK  
No  
Defect

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-11	JCA-M47-1-19

X2

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

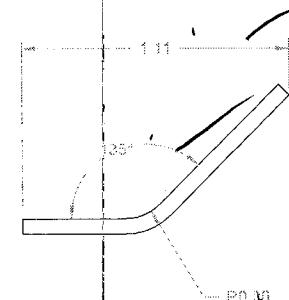
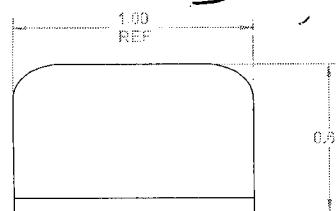
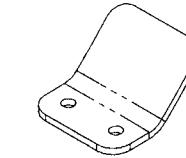
SUBJECT TO AMENDMENT

NOTICE

WORK ORDER

NO. 55843

P10-2-03



D3999-11 EARTH TAB

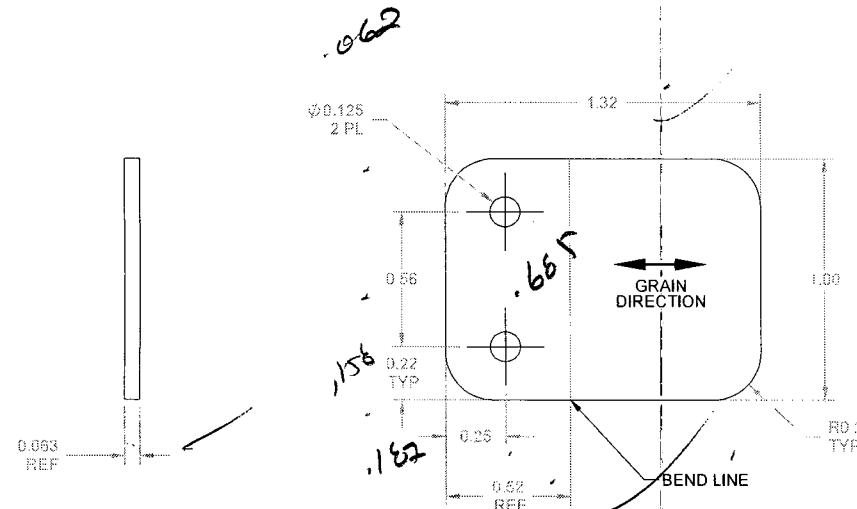
**PRELIMINARY ISSUE**

09.10.07

**NOTES:**

- 1) MATERIAL: MADE FROM D3999-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	<u>1</u>	DART AEROSPACE LTD
DRAWN	<u>1</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>1</u>	REV. PA1
MFG. APPR.	<u>1</u>	SHEET 11 OF 12
APPROVED	<u>1</u>	SCALE
DE APPR.	<u>1</u>	NTS
DATE	09.10.07	COPYRIGHT © 2005 BY DART AEROSPACE LTD
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D3999-11F FLAT PATTERN

NOTES:  
 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
 REF DART SPEC M6061T6S.063  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.01 lbs

**PRELIMINARY ISSUE**

09.10.07

DESIGN	<i>A1</i>	DART AEROSPACE LTD
DRAWN	<i>A1</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>B</i>	REV. PA1
MFG. APPR.	<i>B</i>	DRAWING NO.
APPROVED		SHEET 12 OF 12
DE APPR.		SCALE
DATE	09.10.07	NTS

W/0 55863

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DART AEROSPACE LTD	Work Order:	5863
Description: EARTH TAR	Part Number:	D3999-11
Inspection Dwg: D3999-11 Rev: P2		Page 1 of 1

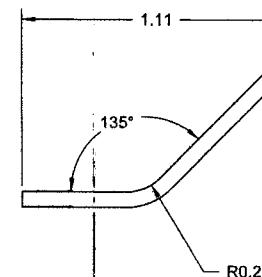
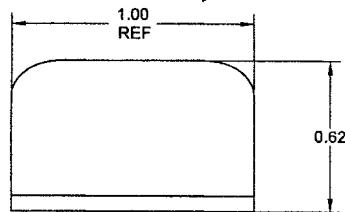
## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

<b>Measured by:</b>	<b>Audited by:</b>	<b>Prototype Approval:</b>
Date: 10-2-17	Date: 10/02/17	Date: N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	/

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-11	JCA-M47-1-19

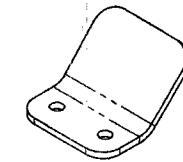


D3999-11 EARTH TAB

NOTES:

- 1) MATERIAL: MADE FROM D3999-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	DRAWING NO. REV. A
MFG. APPR.	<i>AS</i>	D3999 SHEET 11 OF 12
APPROVED	<i>AS</i>	TITLE: SCALE
DE APPR.		BAFFLE NTS
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8 7 6 5 4 3 2 1

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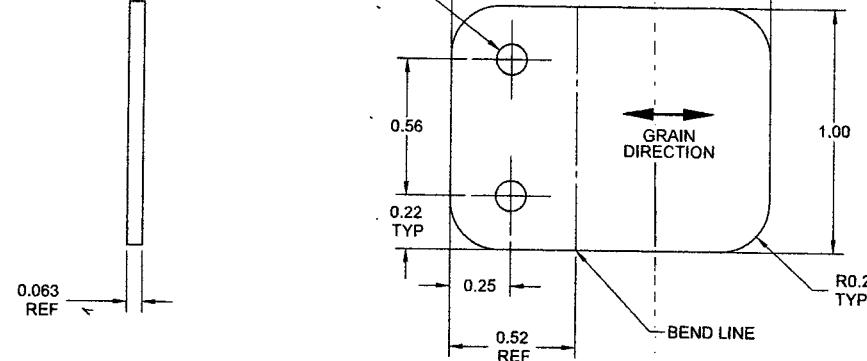
A

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D3999-11F FLAT PATTERN

## NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>BS</i>	DART AEROSPACE LTD
DRAWN	<i>BS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BS</i>	
MFG. APPR.	<i>PE</i>	REV. A
APPROVED	<i>BS</i>	D3999
DE APPR.		SHEET 12 OF 12
DATE	10.02.05	TITLE
		SCALE
		NTS
		BAFFLE

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-11	JCA-M47-1-19

D

D

C

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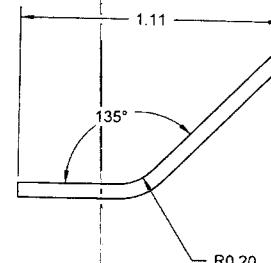
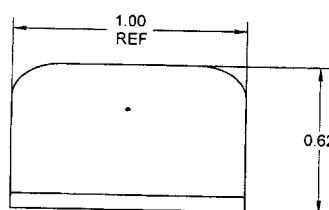
B

A

A

NOTES:

- 1) MATERIAL: MADE FROM D3999-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

**D3999-11 EARTH TAB**

W/055663  
**RELEASED**  
2010-05-05  
M

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. A
MFG. APPR.	<i>[Signature]</i>	DRAWING NO.
APPROVED	<i>[Signature]</i>	D3999
DE APPR.	<i>[Signature]</i>	TITLE
DATE	10.02.05	SCALE
		NTS

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1

D

C

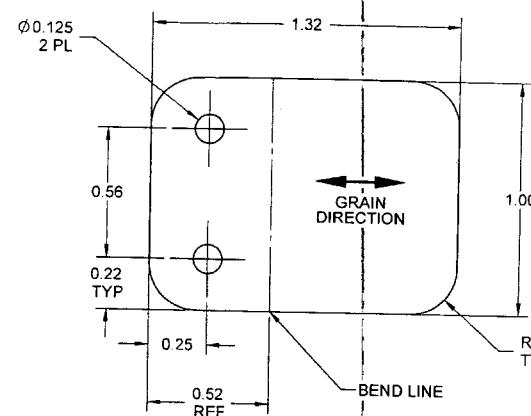
B

D

C

B

A

0.063  
REFD3999-11F FLAT PATTERN

W/0 55863

**RELEASED**  
2010-05-05  
MM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

8

7

6

5

4

3

2

DESIGN	AB	DART AEROSPACE LTD
DRAWN	AB	HAWKESBURY, ONTARIO, CANADA
CHECKED	AB	REV. A
MFG. APPR.	AB	DRAWING NO.
APPROVED	AB	D3999
DE APPR.	AB	TITLE
DATE	10.02.05	SCALE
		NTS

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